

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET		
Job Number	: 30653				
Estimate Number	: 10379				
P.O. Number	: <i>N/A</i>	Part Number	: D3195041		
This Issue	: 2/5/2007	S.O. No.	: <i>N/A</i>	Drawing Number	: D3195 REV A
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: 2/5/2007	Type	: MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27840			Material	: <i>N/A</i>
Written By	: _____	Due Date	: 2/23/2007	Qty:	4 Um: Each
Checked & Approved By	: <i>[Signature]</i> 02.02.05				
Comment	: Est Rev. A New Issue 05-11-08 JLM				

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	2000	2000
3	3000	3000
4	4000	4000
5	5000	5000
6	6000	6000
7	7000	7000
8	8000	8000
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10	10000	10000
11	11000	11000
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100	100000	100000

10	M6061T6B0750X02000	6061-T6 Bar .75" x 2.0"
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Comment: Qty.: 0.3150 f(s)/Unit Total: 1.2600 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)
(M6061T6B0.750x02.000)
Identify for D3195-1
Batch: M100742 J.F. 07/0

20	BAND SAW	BAND SAW
----	----------	----------



Comment: BAND SAW

Cut blanks: (0.75" x 2.00") x 3.60" long

J.F. 07/02/25

30 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3195-1 as per Folio FA334 and Dwg D3195
Identify as D3195-1

Deburr

J.F. 07/02/26

40 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/26

50 QC8 SECOND CHECK



Comment: SECOND CHECK

ΣΑ 07.02.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30653

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

07/02/26

(4)

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

yl

07/02/28

x4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/03/02

x4

9.0

D31955

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3195-5

PAD

B27324

x4

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface

2-Bond D3195-5 into D3195-1 as per Dwg D3195

A/RContact Cement

M 102565

m 07/03/02

x4

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/02

(4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

BU 7/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30653

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

207103105

Job Completion



U 0710305

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

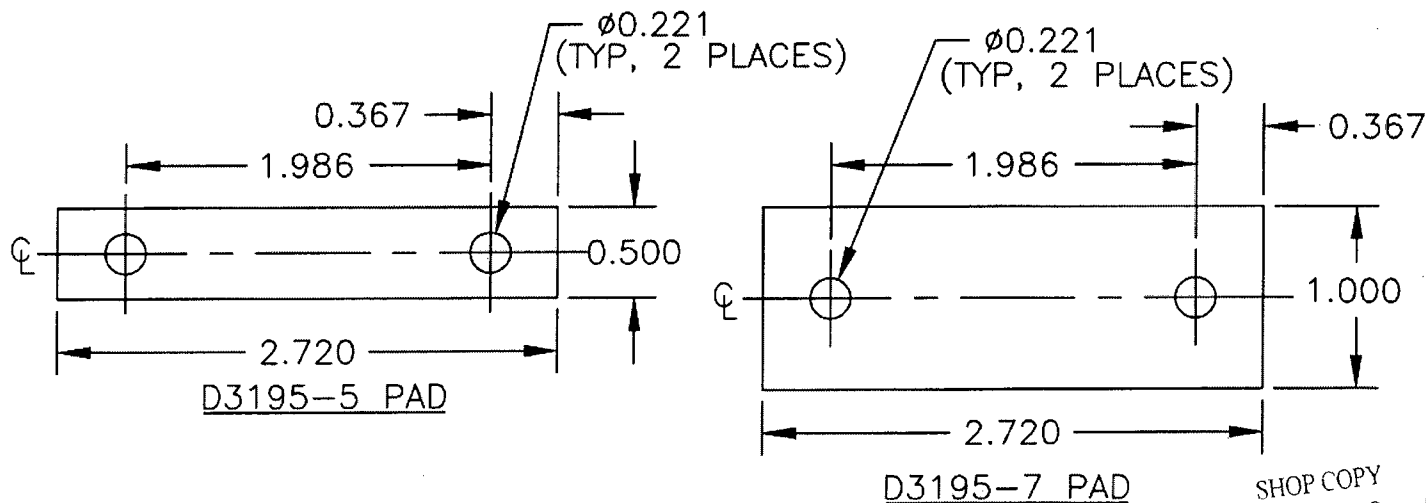
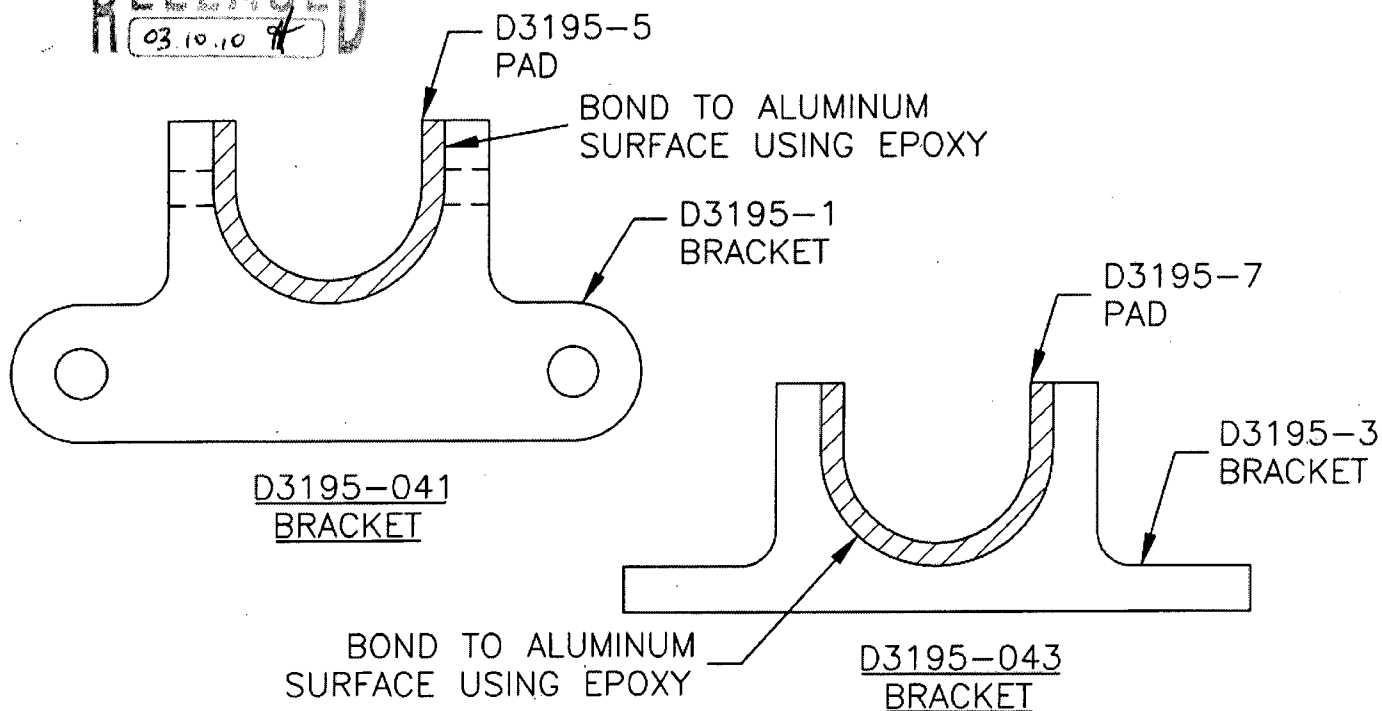
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HP	APPROVED	HP	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23		TITLE BRACKET		SCALE 1:1
A	03.06.23		NEW ISSUE		

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. 30653

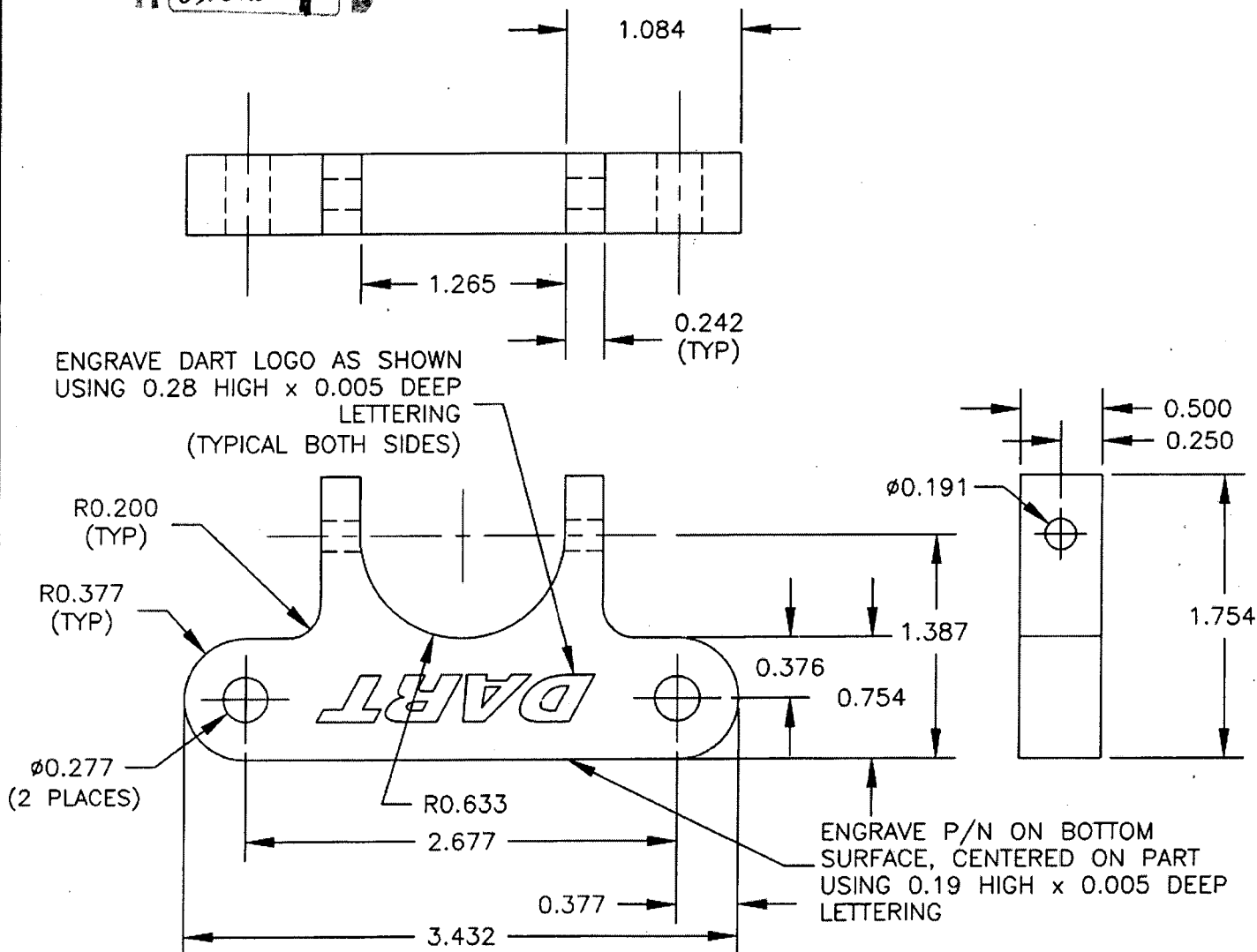
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DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

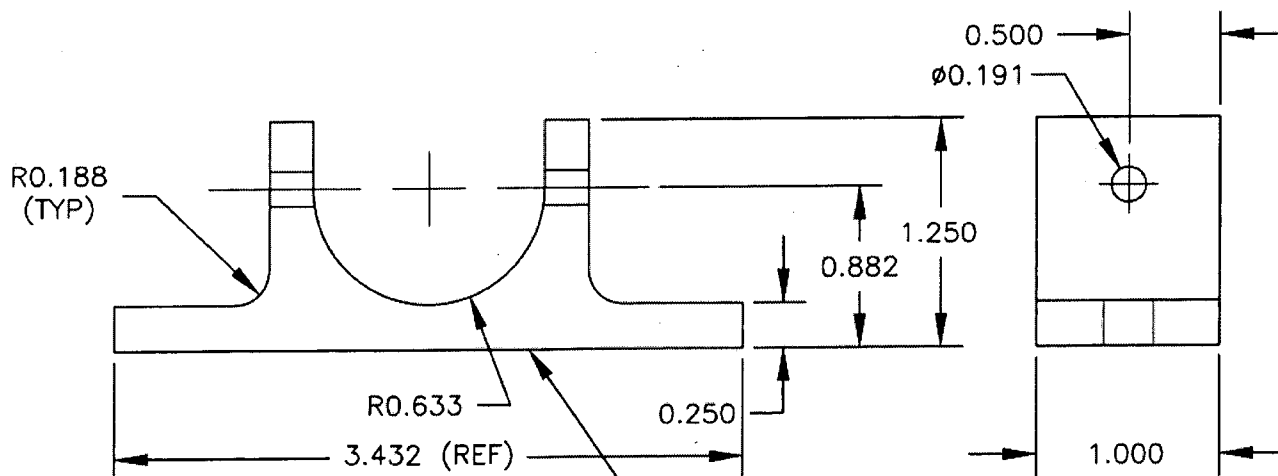
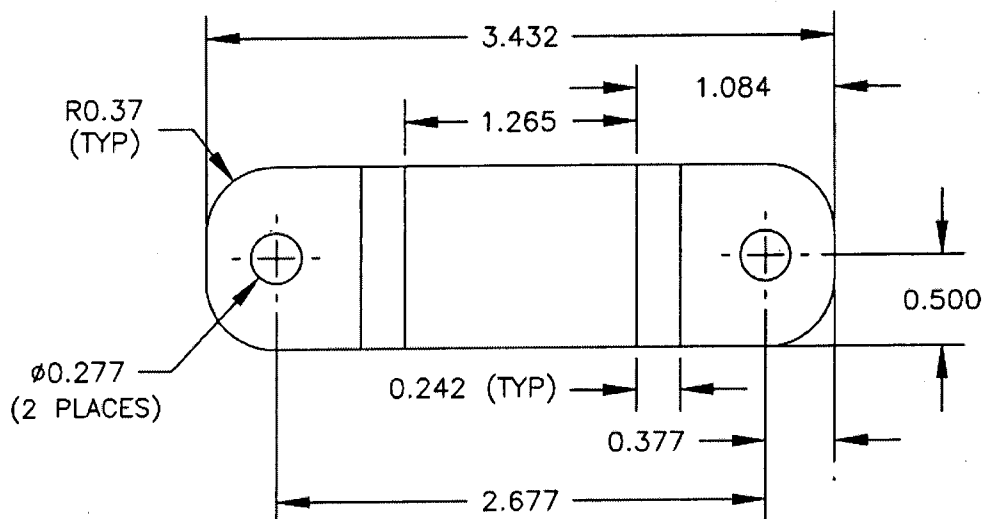
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

ENGRAVE P/N ON BOTTOM
SURFACE, CENTERED ON PART
USING 0.19 HIGH x 0.005 DEEP
LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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